

Date: Friday, 8/25/2006 11:20:45 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW KIT (19"X24")
Job Number	: 28340		
Estimate Number	: 10323		
P.O. Number	: N/A	Part Number	: K10008
This Issue	: 8/25/2006 S.O. No. : N/A	Drawing Number	: D2432 REV F3
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: F3
Previous Run	: 27871	Material	: N/A
Written By	: <i>[Signature]</i>	Due Date	: 9/25/2006
Checked & Approved By	: <i>[Signature]</i> 06-08-25	Qty:	20 Um: Each
Comment	: Est Rev:J 04.02.17 Blank size changed KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile:

K10008

D206-559-013

D350-578-011

D427-659-011

D315-670-011

and create labels per PPP K10008

CHG006(Bag Bluefiles separately)

See Attached.

2.0

MUHMWB10

UHMW 1" Black



Comment: Qty.: 6.8250 sf(s)/Unit Total: 136.5000 sf(s)

blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5

Material: Black UHMW 1"

(MUHMWB10)

Batch:

101254
M100827 / 1 Pcs
↓
*M100827 / 39 Pcs**J.F. 06/09/03**20*

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note:(2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

*J.F. 06/09/11**20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Friday, 8/25/2006 11:20:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 28340

Part Number: K10008

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

WLF J.F. 06/09/11

20

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SD 060914

20

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 0.4166 f(s)/Unit Total : 8.3320 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050 Rubber Cushion

B28042

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274 Radius Block

2 D2432F(ref only) Bearpaw

B28344 23m4

B27581 9m 217mcp

B28340

9.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438 Clamp

B25611 4mcp

B27080 116m4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Process Sheet

Drawing Name: BEARPAW KIT (19"X24")

Part Number: K10008

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[illegible]

✓ 12 D2529 Washer 327876

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6 D2732-050 Rubber Cushion B26472

[illegible]

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✓ 12 AN4-15A Bolt 119185 34mcps.

[illegible][illegible]

12 AN4-17A Bolt M1947 108 mag: 1111
M11124 134 mag: 1111111111

<p> Abstract The purpose of this study was to determine the effect of a 12-week training program on the physical and psychological characteristics of young women. The study was conducted in a laboratory setting. The subjects were 15 young women, aged 18-25, who were divided into two groups: a control group and an experimental group. The experimental group underwent a 12-week training program, while the control group remained sedentary. The physical characteristics measured were body mass index (BMI), body fat percentage, and heart rate. The psychological characteristics measured were anxiety, depression, and self-esteem. The results showed that the experimental group had significantly lower BMI, body fat percentage, and heart rate compared to the control group. Additionally, the experimental group had significantly lower anxiety and depression levels and higher self-esteem levels compared to the control group. The findings suggest that a 12-week training program can effectively improve the physical and psychological characteristics of young women. </p>	<p> Keywords young women, 12-week training program, physical characteristics, psychological characteristics, BMI, body fat percentage, heart rate, anxiety, depression, self-esteem. </p>
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1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

24 AN960JD416 Washer M19/85

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DA Date: 06/01/06

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Friday, 8/25/2006 11:20:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 28340

Part Number: K10008

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 12 MS21042L4 Nut (or -4) M19085

PV 6/9/20 (20)

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



0206/09/21 (20)

Comment: INSPECT 100% KITS FOR COMPLETENESS

PB 06/09/21 (20)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPK10008

Location: -

NRK

Pg 9/21 (20)

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Ha 09-25

Job Completion



W 06-09-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	28340
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

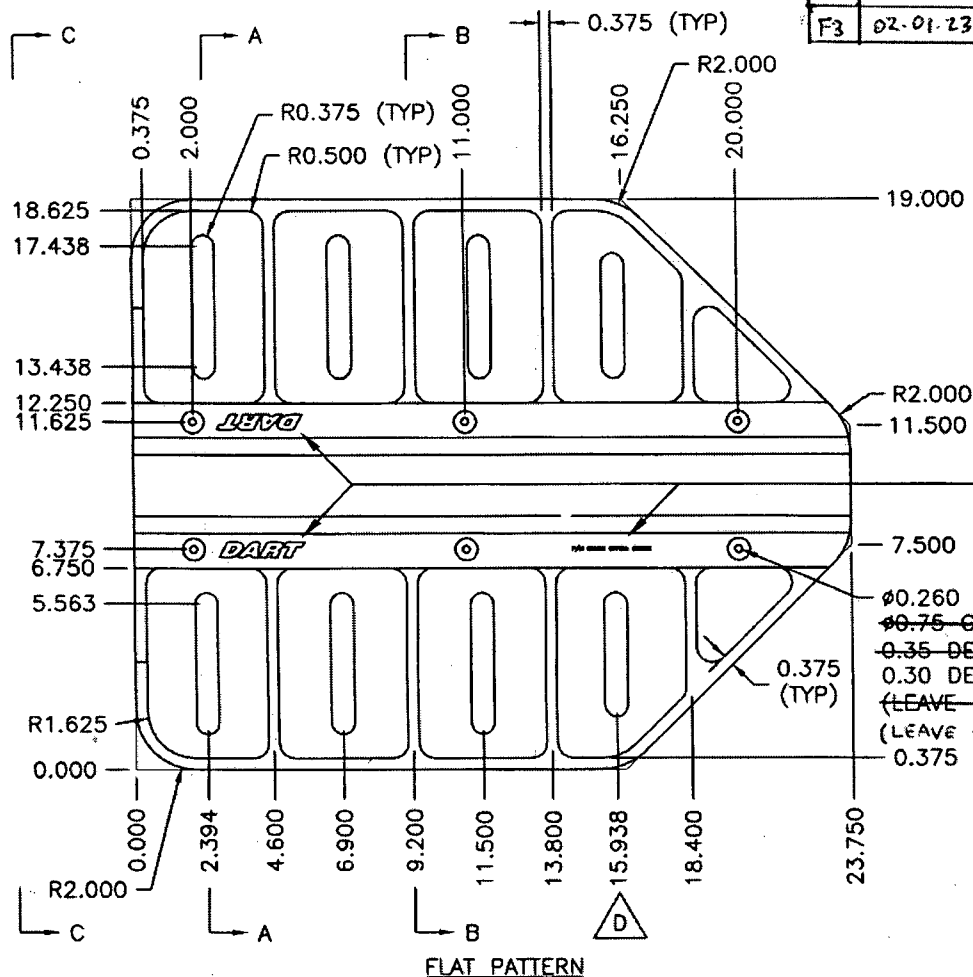
Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063 x 45° ✓			
B	5.500	+/-0.030	5.499" ✓			
C	0.200	+/-0.030	.198" ✓			
D	0.25 x 45°	+/-0.030	.230 x 45° ✓			
E	R0.250	+/-0.030	R0.250" ✓			
F	0.250	+/-0.010	.257" ✓			
G	0.625	+/-0.030	.633" ✓			
H	0.375	+/-0.010	.380" ✓			
I	0.950	+0.030/0.010	.957" ✓			
J	19.000	+/-0.030	19.002" ✓			
K	3.14	+/-0.030	3.145" ✓			
L	3.28	+/-0.030	3.310" ✓			
M	Ø0.260	+0.005/-0.000	Ø.260" ✓			
N	Ø0.93	+/-0.030	Ø.929" ✓			
O	0.30	+0.030/-0.000	.315" ✓			
P	23.750	+/-0.030	23.750" ✓			
Q	7.375	+/-0.030	7.378" ✓			
R	4.250	+/-0.010	4.253" ✓			
S	2.000	+/-0.030	1.997" ✓			
T	9.000	+/-0.010	9.000" ✓			
U	9.000	+/-0.010	9.000" ✓			
V	0.375	+/-0.010	.380" ✓			

Measured by: J.F.	Audited by: S.D.	Prototype Approval: N/A
Date: 06/09/03	Date: 06.09.04	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O K10008/D206-559-015	KJ/RF	TF

RELEASED
98-06-17 KES

F1	99.03.03	ADD DEC 9143
F2	01.03.28	$\phi 0.93$ WAS $\phi 0.75$ RF
F3	02-01-23	CLARIFY CORE DIMS RF






ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

DESIGN		DRAWN BY		DART AEROSPACE LTD	
KE		KE		HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. F	
MM	JS	D2432		SHEET 1 OF 2	
DATE		TITLE		SCALE	
98.05.12		BEARPAW		1:6	
A	95.10.31	NEW ISSUE			
B	96.01.24	RE-DESIGN			
C	96.03.26	CHANGE BORE AND C'BORE DEPTH			
D	96.06.04	MOVE SLOT			
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS			
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N			

EFFECTIVE DEOS

9143

~~0.260 (TYP)~~ 
~~0.75 C'BORE~~ ~~0.43 C'BORE~~
~~0.35 DEEP FROM TOP (MIN.)~~
 0.30 DEEP FROM BOTTOM
 (LEAVE 0.300 MIN.) 
 (LEAVE 0.650 MIN.)
~~0.375~~ 

BEND AFTER MACHINING
(D2432B ONLY)

- 0.950 (REF)

D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

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SHOP COPY
SUBJECT TO AMENDMENT

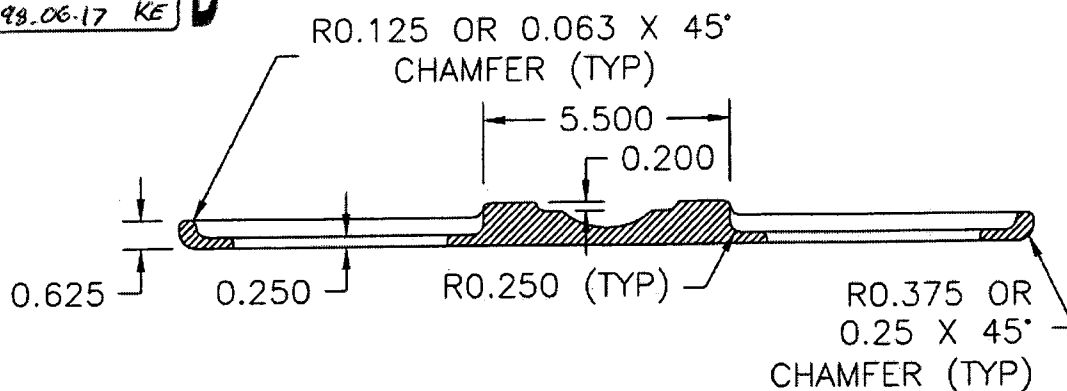
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WORK ORDER
NO. 28327C

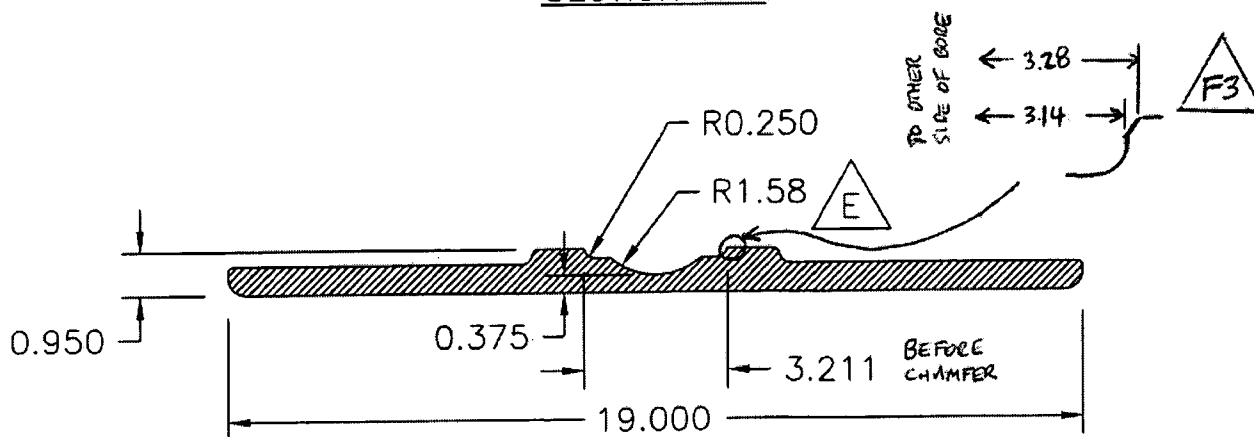


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ME	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

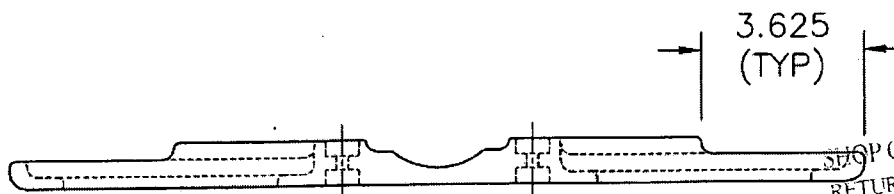
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

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WITHOUT NOTICE
WORK ORDER
NO. 28340

Date: Friday, 8/25/2006 11:20:45 AM
User: Kim Johnston

Process Sheet

39

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 28340
Estimate Number : 10323
P.O. Number :
This Issue : 8/25/2006 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : MACHINED PARTS
Previous Run : 27871
Written By :
Checked & Approved By :
Comment : Est Rev: J 04.02.17 Blank size changed KJ/JLM

Drawing Name : BEARPAW KIT (19"X24")
Part Number : K10008
Drawing Number : D2432 REV F3
Project Number : N/A
Drawing Revision : F3
Material :
Due Date : 9/25/2006 Qty: 20 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile:

K10008 ✓

D206-559-013 ✓

D350-578-011 ✓

D427-659-011

D315-670-011

and create labels per PPP K10008

CHG006(Bag Bluefiles separately)

REFERENCE ONLY

06.09.08

2.0

MUHMWB10

UHMW 1" Black



Comment: Qty.: 6.8250 sf(s)/Unit Total : 136.5000 sf(s)
blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5
Material: Black UHMW 1"
(MUHMWB10)
Batch: _____

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note:(2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr